

Date: Wednesday, 1/25/2006 2:31:19 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER ASSEMBLY , RH
Job Number	: 25626		
Estimate Number	: 10918		
P.O. Number	: N/A	Part Number	: D3163042
This Issue	: 1/25/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3163 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: C
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 2/1/2006
Checked & Approved By	: <u>See Comment Below</u>	Qty:	3
Comment	: Est. A 05.10.25 New issue KJ/RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31631	Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Plate

Pick:

Qty	Part Number	Description	Batch
1	D3163-1	Plate	B 25022

FF 06-01-24

3

2.0	D31633	Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Plate

Pick:

Qty	Part Number	Description	Batch
1	D3163-3	Plate	B 25023

A/R	N/A	Sikaflex 241/291	M 19134
Expiry Date:			06-06-20

Bond D3163-3 to D3163-1 using Sikaflex.

Ensure holes line up

FF 06-01-26

3

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond D3163-3 to D3163-1 using Sikaflex. Ensure holes line up

FF 06-01-26

3

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Inspect bonding of D3163-1/-3

206-01-31

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: COVER ASSEMBLY , RH

Job Number: 25626

Part Number: D3163042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.m 06-02-09

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 06-02-10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

C'sink D3163-3 as per Dwg D3163.

Touch up c'sink holes with alodine.

8.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

RIVET

Pick:

Qty

Part Number

Description

Batch

2

MS20426AD3-4

Rivet

M 15786

FF 06-02-15

③

9.0

MS21059L08

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

1

MS21059L08

Nut Plate

M 10015/m 12706

Assemble nut plate as per Dwg D3163

Identify as D3163-042

FF 06-02-15

③

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-15

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify top assembly on the back side of assembly with Dart P/N and B/N using fine point permanent ink marker and Stock

Location: _____

CY 06/02/15 (3)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

505 06/02/17

(3)

DP 06/02/16 (3)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries